DART AEROSPACE LTD			Work Order:	24451	
Description: Bracket Assembly			**Part Number:**	D3162-043	
Dwg: D3162 Rev. C page 2			**Qty:**	3	
				Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	RF	05.10.05	3
2	GA	Cut blank: 1.850" x 1.110" Material: 6061-T6 Sheet (QQ-A-250/11) (M6061T6S.063) **Identify for D3162-3** Batch: _M18556_	ml	05/10/17	3
3	GA	Form as per Dwg D3162	ml	05/10/17	3
4	GA	C'sink for rivet MS20426AD3-4 as per Dwg D3162 **Note: Confirm orientation for D3162-043**	ml	05/10/17	3
5	GA	Finish fabricating one side by cutting R0.25 **Identify as D3162-3**	ml	05/10/17	3
6	QC5	Inspect work to Step 5	RF	05.10/17	3
7	FP	Chemical Conversion Coat as per QSI 005 4.1	ml	05/10/17	3
8	QC3	Inspect Chemical Conversion Coat	RF	05.10/17	3
9	GA	Assemble as per Dwg D3162 **Pick:** Qty Part number Description Batch 2 MS20426AD3-4 Rivet _m15786_ 1 MS21059L3 Nut Plate _M12240_ **Identify as D3162-043**	ml	05|10|17	3
10	QC5	Inspect work to Step 9	RF	05/10/17	3
11	ST	Identify with P/N and B/N using fine print permanent ink marker and Stock	ml	05/10/17	3
12	AC	Cost / part: _31,49_	SYC	05-10-18	3
13	DC	Close W/O _31,49_ Inspect Level 21		05/10/18	3

Rev	Date	Change	Revised By	Approved
A	05.10.14	New issue	KJ/RF	RF

PRELIMINARY ISSUE

DESIGN	DRAWN BY	**DART AEROSPACE LTD**	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3162	SHEET 2 OF 2
DATE		TITLE	SCALE
05.10.05		BRACKET ASSEMBLY	1:2

ø0.098
C'SINK ø0.190 x 100°
(2 PLS)

R0.12
(TYP)

0.688

0.344 (TYP)

1.250

1.110   GRAIN
DIRECTION

0.226

ø0.250

1.850
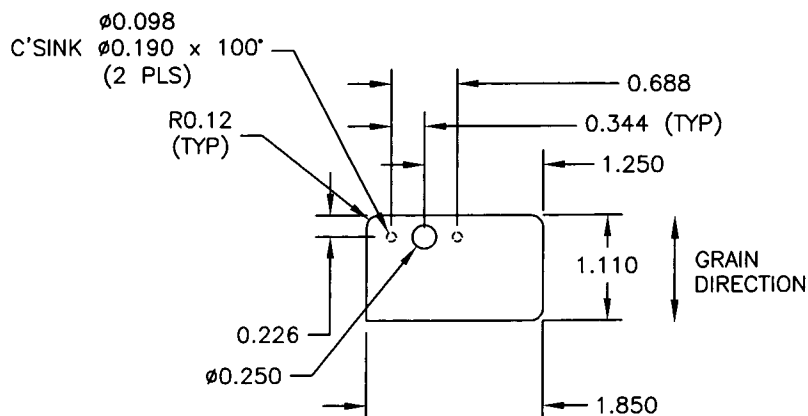
D3162-3/-4 BRACKET FLAT PATTERN

MS21059L3 NUTPLATE (1)
MS20426AD3-4 RIVET (2)

0.590

0.65

0.450

R0.125

R0.25

1.250
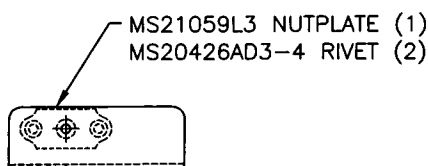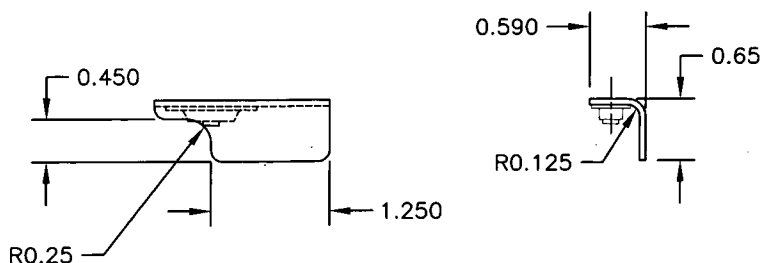
D3162-043 BRACKET ASSEMBLY (SHOWN).
(D3162-044 BRACKET ASSEMBLY (OPPOSITE)

NOTES:
1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER